

Date: Thursday, 10/04/2008 4:00:53 PM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPAD
Job Number : 38548	
Estimate Number : 12785	
P.O. Number :	Part Number : D356411
This Issue : 10/04/2008 S.O. No. :	Drawing Number : D3564 REVD
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : SMALL / MED FAB	Drawing Revision : D
Previous Run : 37811	Material :
Written By :	Due Date : 30/04/2008 Qty: 30 Um: Each
Checked & Approved By : JB 08.4.10	
Comment : Est Rev:A New Issue 07-03-08 ec	
Est Rev:B As per Rev C 07-07-09 JLM	
Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC	



Additional Product

Job Number: 



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	
		

Comment: Qty.: 1.48050 sf(s)/Unit Total: 44.41500 sf(s)
M304S16GA Stainless steel sheet 0.063" thick
Batch: 101676 IB 8-4-14

2.0	WATER JET	FLOW WATER JET
		



Comment: FLOW WATER JET
1-Cut as per Dwg D3564 ***** (D3564-1F) *****
Dwg Rev: D IB 8-4-14
Prog Rev: D
2-Deburr if necessary IB 8-4-14

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
		

Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
		

Comment: NC BRAKE
Deburr if necessary
Form on Brake as per Dwg D3564 using Jigs DT 8179 and DT 8155

JB 08/04/17

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Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

08/04/17 (132)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

A/R 2059B Hardcoat

M 106015

Weld hardcoat as per Dwg D3437

08-04-29 SP (6X)

8.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

08/04/29 (6X)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/29 (6X)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 105442

08-04-30

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 08/04/30

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

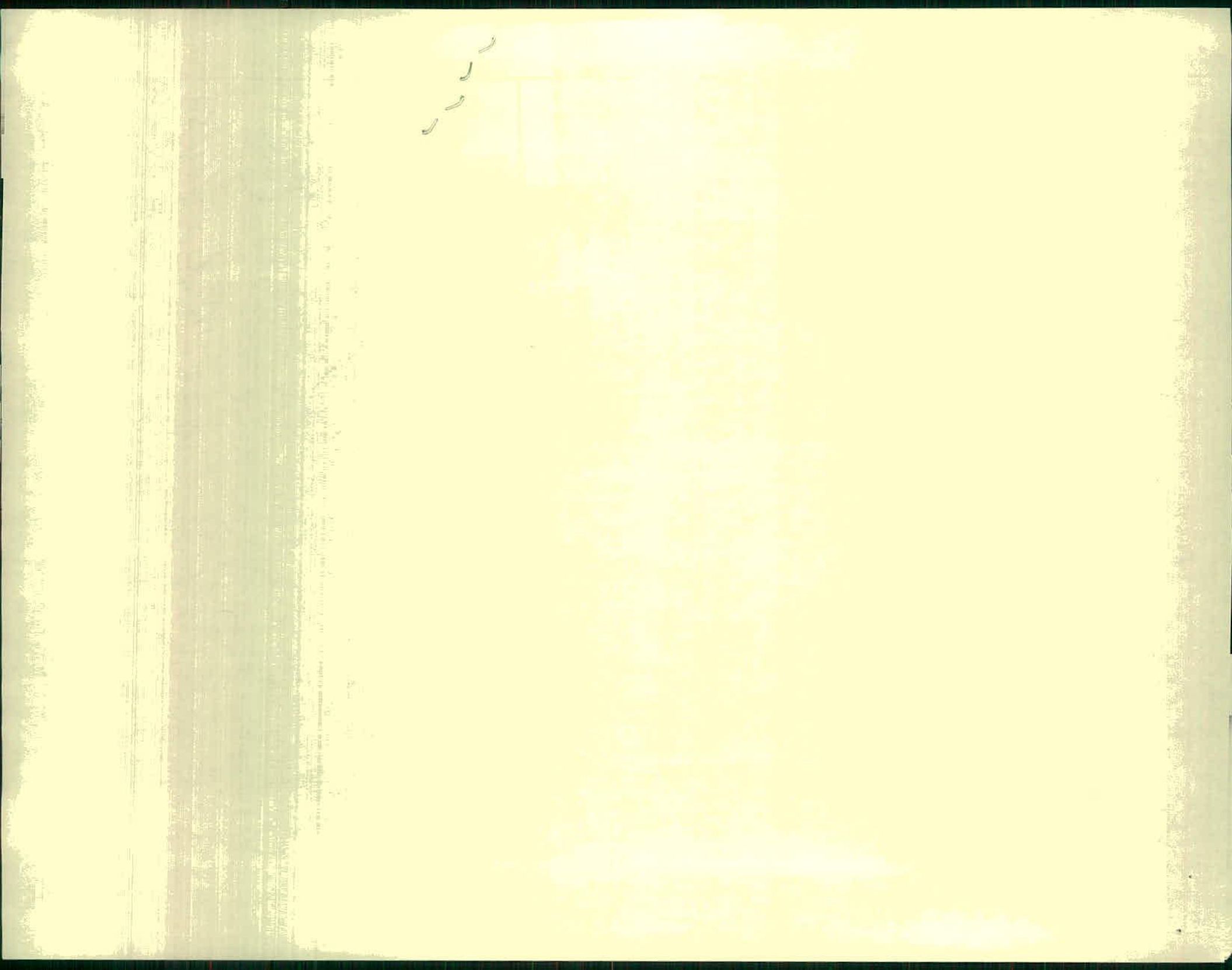
Identify and Stock

Location: F-P-18

M-L 08/04/30

MF 08-0430

B 38548
D 356411
30/04/2008
S.156 08.27
#1 318.7 F
#2 777.7 F
#3 70 F
#4 70 F



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Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



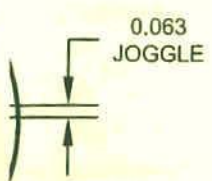
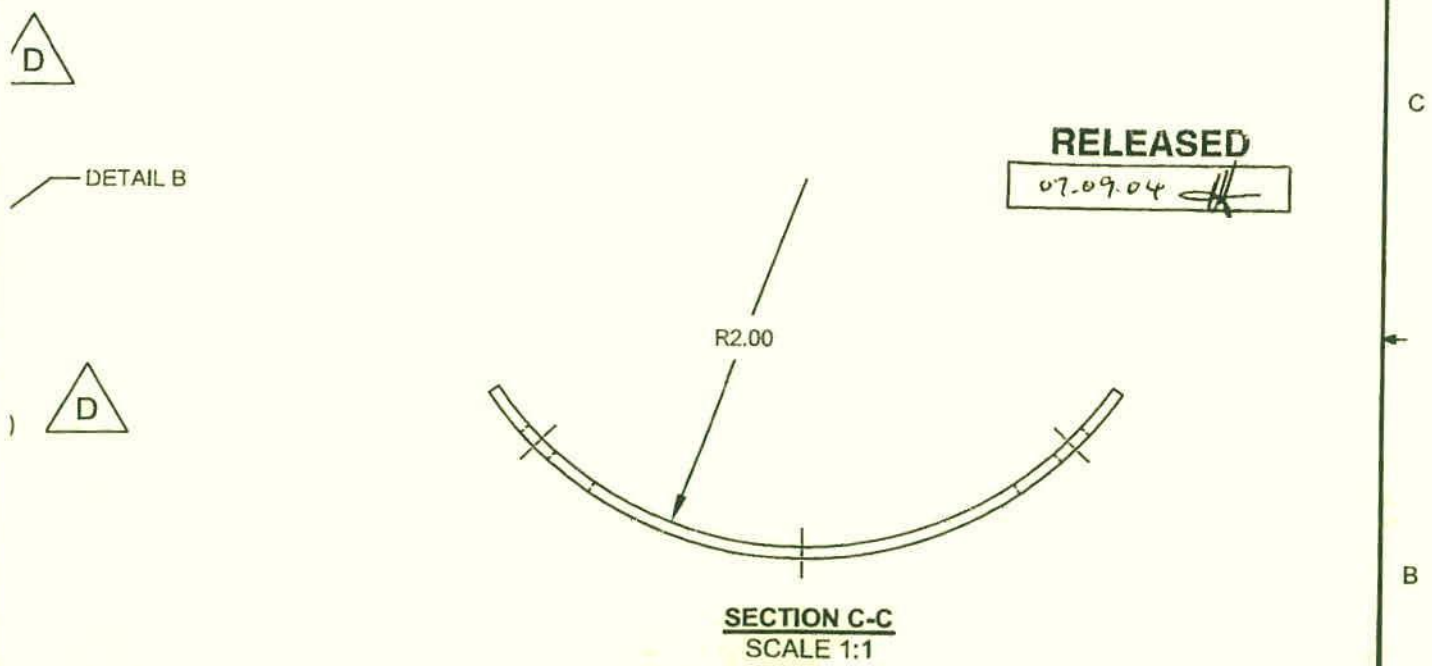
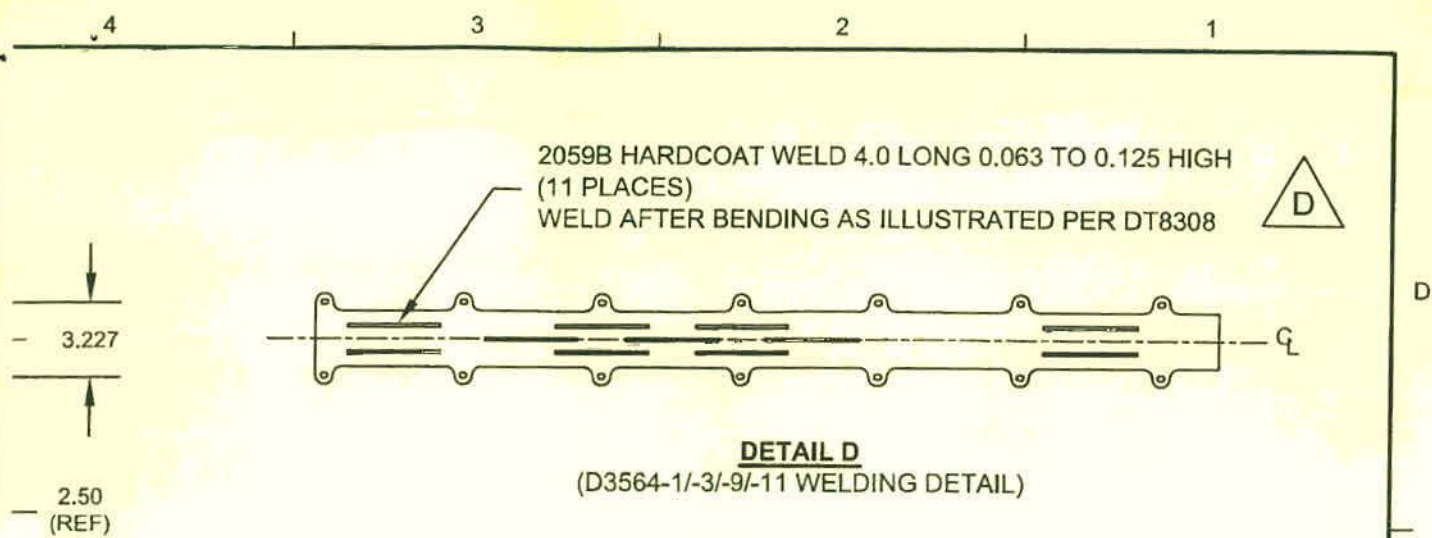
08/05/01 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



See previous sheet



DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
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